

Work Order ID 95068-2

January-02-13 1:00:31 PM

95068

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Item ID: D4434-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Outboard Bracket Assembly

Start Date: 1/02/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/18/13

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 13-01-03 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4434

B

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Assemble cover and bracket together as per dwg (SEE NOTE 9)

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

FF
13-02-08

SM
B.2.11



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Item ID: D4434-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Outboard Bracket Assembly

Start Date: 1/02/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/18/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Powdercoat Powder Coating	Black Sandtex(Ref:4,3,5,7) per QSI005 4.3 <i>MVB3480</i> Memo *** MASK NUT PLATE HOLES AS PER DWG *** START TIME: <i>11:30</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>12:05</i>	0.00 0.00				<i>1</i>	<i>0</i>	<i>120211</i>	
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>24 305</i>		<i>1</i>			<i>13/02/11</i>
140 *140* Small Fab Small Fab	Install rubber seal as per dwg <i>M124297</i>	0.00 0.00				<i>1</i>			<i>FF 13-02-11</i>



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Item ID: D4434-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Outboard Bracket Assembly

Stop ***NS2***

Start Date: 1/02/13 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 1/18/13 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DA
30
P

13/02/12

160

0.00

160

Packaging

Memo

0.00

Packaging

GA

SP
13/02/12

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

13/2/14

04700

MR

13-2-14



Picklist Print

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Page 1

Work Order ID: 95068

Parent Item: D4434-045

Parent Item Name: Fwd Outboard Bracket Assembly

Start Date: 1/02/13

Required Date: 1/18/13

Start Qty: 6.00

Required Qty: 6.00

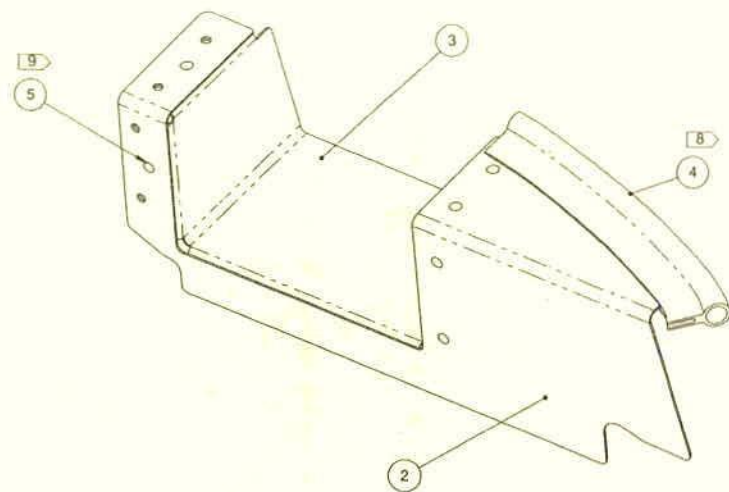
Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PAS
EC verified by:JLM IPP RevC 12.01.24 per REV.A DD verified by:EC
IPP RevD 12.03.05 per REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-3 Bracket		Manufactured	No			100	Each	3.0000	1	6		FF 13-02-08	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		3	95172	(7)					
				82295		1							
				93400		2							
D4434-5 Bracket		Manufactured	No			100	Each	0.0000	1	6		FF 13-02-08	
D4441-1 Rubber Seal		Manufactured	No			100		550.3418	0.5	3		FF 13-02-08	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST412		550.3418	D						
				74760		6.119							
				79385		0.0475							
				80763		78.7672		0.5					
				86185		465.408							
MS20426AD4-4 Rivet		Purchased	No			100	Each	814.0000	6	36		FF 13-02-08	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		814							
				121090		814		6					



95068

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
2	1	D4434-3	BRACKET
3	1	D4434-5	BRACKET
4	1	D4441-1-060	RUBBER SEAL
5	6	MS20426AD4-4	RIVET



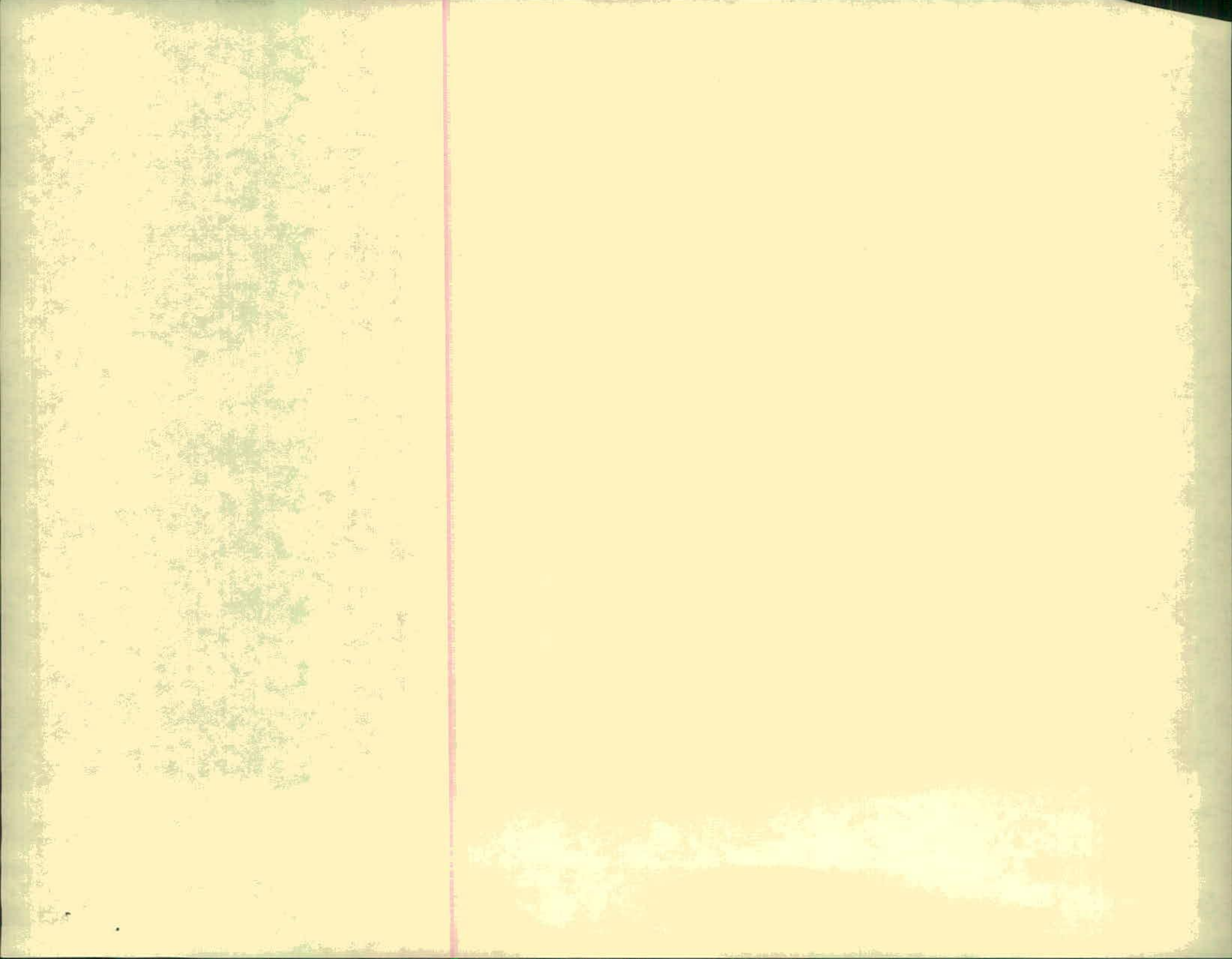
D4434-045 FWD OUTBOARD BRACKET ASSEMBLY

RELEASED
2012-03-02
MR

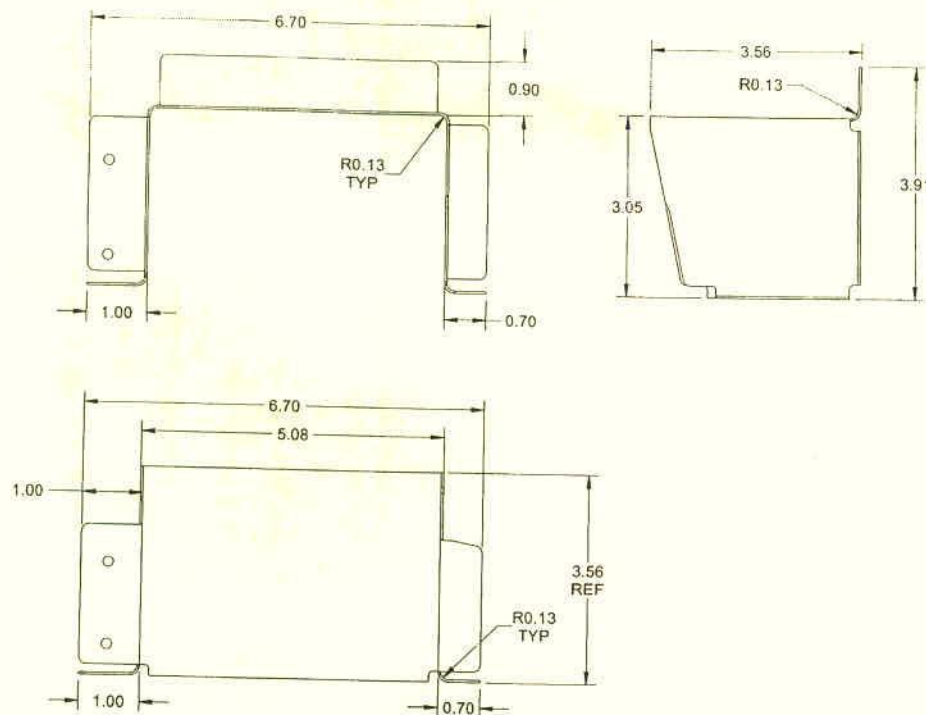
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.365 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE.
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TRANSFER $\phi 0.129$ HOLE 6 PLACES AND CSK TO $\phi 0.225 \times 100^\circ$

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MR	DRAWING NO.	REV. B
MFG. APPR.	EE	D4434	SHEET 4 OF 15
APPROVED	MR	TITLE	SCALE
DE APPR.	MR	COVER ASSEMBLY	NTS
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D4434-5 BRACKET

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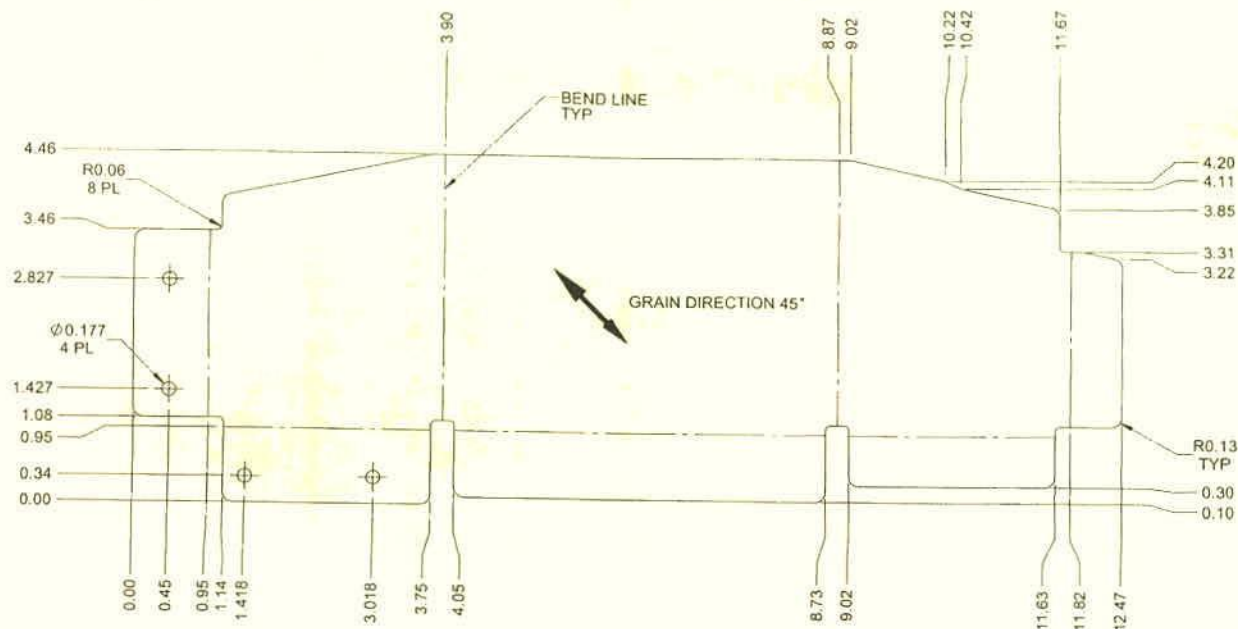
NOTES:

- 1) MATERIAL: MAKE FROM D4434-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>WJ</i>	DRAWING NO. D4434	REV. B
MFG. APPR.	<i>E</i>		SHEET 10 OF 15
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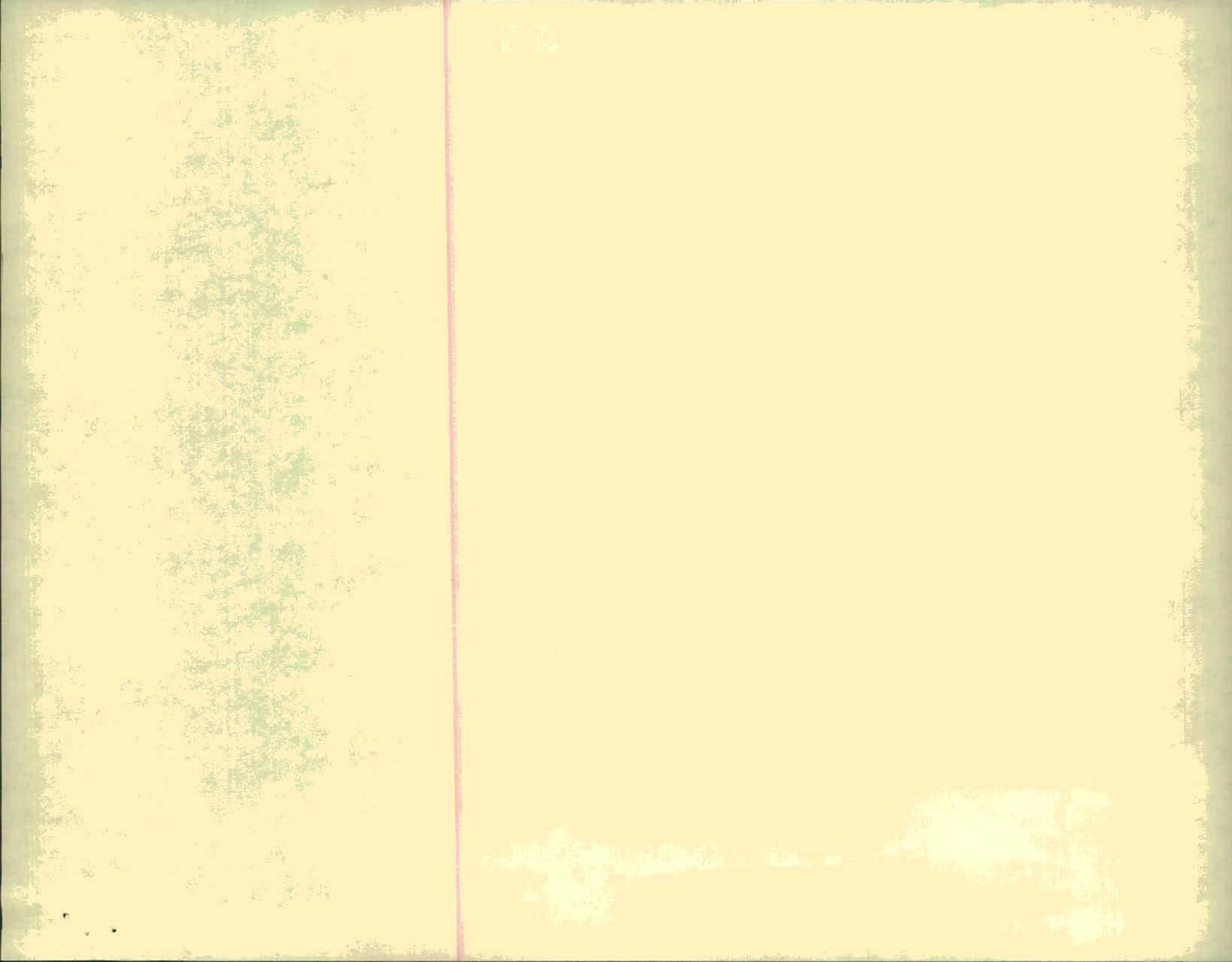
D4434-5F FLAT PATTERN

NOTES:

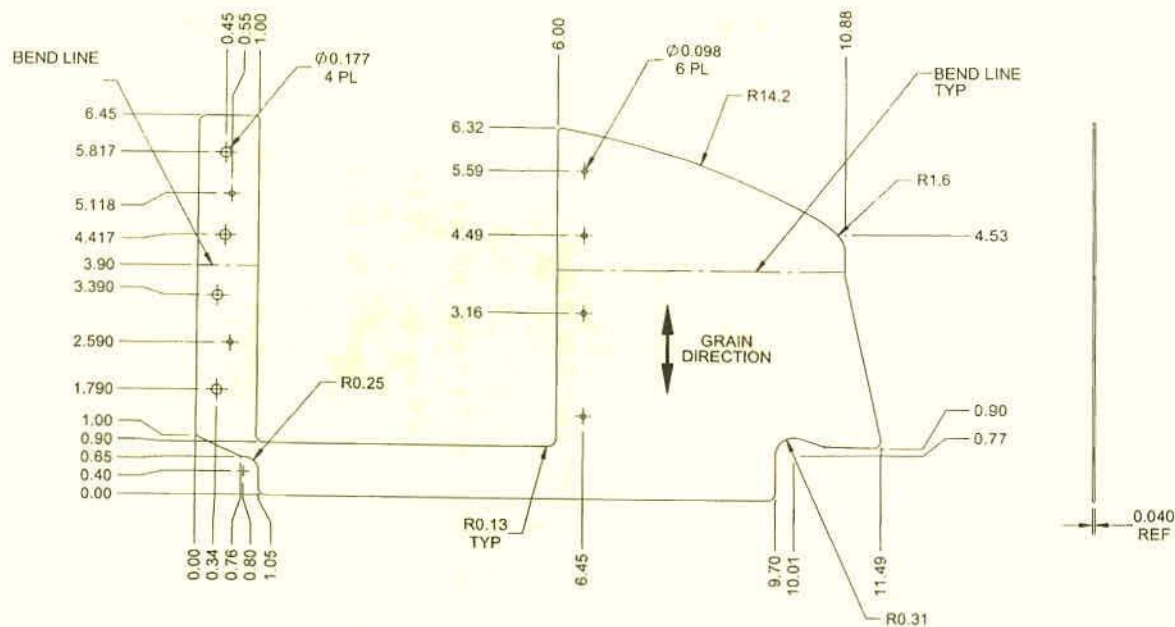
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

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2012-03-02



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D4434-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

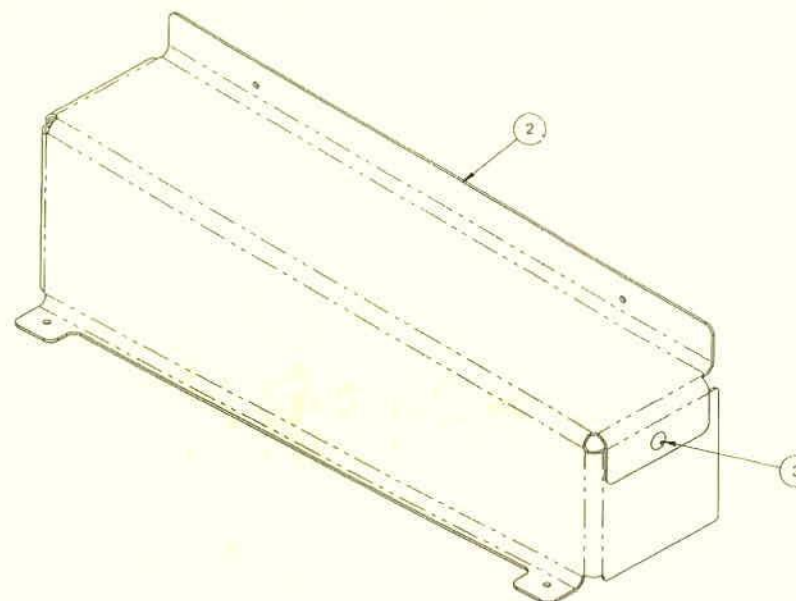
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D4434-047	COVER ASSEMBLY
2	1	D4434-7	BRACKET
3	2	MS20470AD4-3	RIVET



D4434-047 COVER ASSEMBLY

RELEASED
2012-03-02
NW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.263 lbs

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